1.4	Work Orde une-12-13 9:14		02809		*102	2809*						Page 1
	tem ID: Revision ID:	D3204-5		•	Accept	*N900	040	100)*	Setup Start	1.71	S1*
I	tem Name:	Arm		j						Stop	*N	S2*
S	tart Date:	6/11/13	Start Qty: 16.00	*16*		Cust Item 1	ID:					
F	Required Date:	6/11/13	Req'd Qty: 16.00	*16*		Customer:						
F	Reference:			į.		•						
A	Approvals:	Process P	lan: _ Mしろ	Date: 13-06-17	Tooling:	D	ate:	-	I	Run Star	*N	R1*
	ř.	45		Date:		D	ate:			Stop	*NI	D2*
							T 1 "	DI			1 7	N /
	equence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	Draw Nbr		evision Nbr			-, -						
	D3204	Re	ev A1									
_3	100	· · · · · · · · · · · · · · · · · · ·	·	, ,	0.00							
•	*100* Bandsaw		BAND SAW				MLI	(3	1.6	/ 23	10	$\boldsymbol{\alpha}$
			Memo		0.00		12/14	12	100	(})	1-3	P
J	easpa Bandsaw		Cut blank: 1.	25" x 0.375" x 3.370" long	(Bar (+0.030/-0.000)							€ •
					.=							
,					0.00	No L		-1-	110	11	1	
	110 * 4 4 0 *		HAAS CNC VERTICAL	MACHINING #1	0.00	DRF	272 1	3/87	117	10	Ø.	**
	110 HAAS I		Memo		0.00	•						
ŀ	HAAS CNC vertical	l machine #1		as per Folio FA344 and Dw	g D32042- DeburrIdenti	ify as D3204-	, e					
	· •		5									
						,					, .	
I	120		QC2- Inspect parts off ma	achine FAI/FAIB	0.00	All	1	13/	10/19	3 16		
	120					M	~)~	111		<i>/ 0</i>		
	QC		Memo		0.00	,						
(Quality Control											

DQA: Date:														
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		Work (Order up	odate only	\neg	AEROSPACE
					DISPOSITION	-			AGAINST	•				
Work Order	r:			_							•	-	_	
Part No	O			Ì	Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Pro	Water Jet d. Eng. Coor.	\dashv	Engineering Quality
· uiti	·	· · ·		-	Use-as-is			noforming	Finishing			e/Packaging	\dashv	Other
NCR N	0.				Suspected Unapproved		111011	Large Fab	Composite	\dashv	1100/3101	Supplier	\exists	
				_				· <u> </u>					_	
Root				Desci	ription of work order update	1	nitial	Acti	on	S	ign &		T	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	<u> </u>	QC Inspector
Design														
Doc/Data						ļ								
Equip/Tooling														
Handling/Pre														
Material		į			•									
Operator														
Offset/Setup														
Process														
Supplier														
Training		1.								İ	-			
Transport														
Unapproved													- 1	
						FAL	ULT CA	TEGORY						
Landin	g Gear				General			,						
	Bending				Bend		Folio/F	Program		Out	tside Dim	ensions		Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain			Ove	er/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Par	t Incorrec	:t		Temperature/Cure
· [Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Par	t Lost/Mi	ssing	Π,	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Par	t Moved		\Box	Wrong Stock Pulled
Γ	Crushing				Countersink		Misalia	ned/off center		Pos	sitioned V	ا √rong		J
•	Heat Tre	at			Cut Too Short		Mislabe	-			wer Loss/:	· ·	\Box	Other
Ţ	Inspection	on Strip in	Tube		Drawing		Misread				•	- L		
	Marks/C				Drill Holes		Off-set							
					Finish		1	Calibration						
	Turning Sequence Wave/Twist in Tube				Fit/Function			Sequence						

Work Order ID			*102	2809*							Page 2
Item ID: D320 Revision ID: Item Name: Arm			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	*N:	S1*
Start Date: 6/11/2 Required Date: 6/11/2 Reference:	- •		6* 6*	Cust Item :	ID:					14.	
Approvals: Proc	ess Plan:				ate:				Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect pa	rts - second check	0.00				_16				JL 13-7-23
140 *140 Packaging Packaging	ldentify as per d Mei	wg & Stock Location: K	0.00 0.00				16x				D B-7
*150 *150*	QC21- Final Ins	pection - Work Order Relea	ase 0.00						13	1/2/6	244

Quality Control

13/7/24 D

DQA: Date:						DART								
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UI		/ork Order uj	ndate only	AEROSPACE	
QA CIOSCU.			Dutc.									······································		
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
	-			·		Rework	Rework			Skid-tube Crosstube			Engineering	
Part N	lo.					Scrap			Machining	Small Fab	_	d. Eng. Coor.	Quality	
NCDA						Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	١٥					Suspected Unapproved	J		Large Fab	Composite		Supplier		
Root	Ī				Descr	iption of work order update		Initial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector	
Design	_										:			
Doc/Data						•							·	
Equip/Tooling	\dashv													
Handling/Pre												Ì		
Material	\div					•			-					
Operator														
Offset/Setup Process		, .	(-1	ار د	15					•,`				
Supplier	-			`	'					,				
Training	\dashv													
Transport														
Unapproved					[
			•		L		FA	ULT CA	TEGORY			<u> </u>		
Landi	ng G	Gear				General								
		Bending				Bend		Folio/F	Program		Outside Dim	nensions	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
		Çracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs	Π	Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld	
		Cuffs				Contamination .		Instruct	tions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misalig	ned/off center		Positioned \	Wrong	·	
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	'Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	-			-	
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S				Finish		Out of	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of:	Sequence						

June-12-13 9:14:31 AM

Work Order ID:

102809

Parent Item:

D3204-5

Parent Item Name:

Arm

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 16.00

Required Qty: 16.00

IPP.

C05 08 11Added Step 25 KJ/JLM

Component Item ID/ Item Name	 Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.250	 Purchased	No		****	100	f	8.1000	0.2913	4.9061050	5		
6061-T6 Bar 375 x 1 25								-,				

Location Loc Oty MAT002 **120243**

8.1

8.1

Loc Code

MH 13/06/23 4.906

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE	
						DISPOSITION		i	AGAINST	DEPARTMENT/PROCESS				
Work Orde	er: _					_ ·							,	
						Rework			Skid-tube Crosstube		Water Jet		Engineering	
Part N	NO					Scrap			Machining Small Fab	\vdash	-	d. Eng. Coor.	Quality	
NCR N	مام					Use-as-is Suspected Unapproved		inern	noforming Finishing Large Fab Composite	_	Rec/Stol	re/Packaging	Other	
INCK	1 0					Suspected Onapproved]		Large Fab Composite	· L	j	Supplier	J LJ	
Root					Desc	ription of work order update	ı	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design														
Doc/Data			İ			•								
Equip/Tooling							İ							
Handling/Pre														
Material														
Operator														
Offset/Setup	Ш													
Process	Щ													
Supplier														
Training	Ц													
Transport	Ц													
Unapproved				L.,	l ,	*	<u> </u>				<u></u>			
	····					<u> </u>	FAI	ULT CA	TEGORY					
Landi						General		1		_	7	_	۱	
	-	Bending	_		<u> </u>	Bend	<u> </u>	1	Program	\vdash	Outside Dim	<u> </u>	Pressure/Forced	
	\vdash	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		_	Over/Under	 	Set-up	
	${f H}$	Cracks		4		Broken/Damage/Defect	<u></u>	Hardwa		-	Part Incorre		Temperature/Cure	
	Н	Crimp/Kir	nk/Ripple	/Wave	-	Burrs	<u> </u>	1	ion Incomplete/Unqualified	-	Part Lost/Mi	ssing	Weld	
		Cuffs			ļ	Contamination	<u> </u>	4	tions Incomplete/Unclear	\vdash	Part Moved	L	Wrong Stock Pulled	
	_	Crushing			<u> </u>	Countersink	-	• `	gned/off center	\vdash	Positioned V		ا ا	
	\vdash	Heat Trea			-	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge	Other	
		Inspectio		Tube	\vdash	Drawing	\vdash	Misrea						
	\vdash	Marks/Ch			\vdash	Drill Holes	<u> </u>	Off-set					<u></u>	
	—	Turning S Maye/Tw	-		<u> </u>	Finish Fit/Function	-	4	Calibration					
	, 11	MILANE W	nctin liik	10		LEU LEUDCTION		II list of	SAGUANCA					

DART AEROSPACE LTD	Work Order:	107,809
Description: Arm	Part Number:	D3204-5
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
R0.375	+/-0.010					1 (
0.750	+/-0.010	375	<u> </u>	<u> </u>	DROS	6" veren	ა
R0.50		.754					
	+/-0.030	.501					
R0.500	+/-0.010	,500.	-				
Ø0.760	+0.005/-0.000	.760					
0.080	+/-0.010	.78					
2.373	+/-0.005	2.373					
Ø0.375	+0.005/-0.000	.376					
0.250	+/-0.010	126.					
R0.06	+/-0.030	,06					
0.200	+/-0.010	.200					
							
							
•							
leasured by:	2	Audited by:			Prototype A		N/A

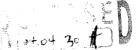
		· · · · · · · · · · · · · · · · · · ·		
Measured by:	Audited by:	Proto	type Approval:	N/A
Date: 13/07/19	Date:	13-7-22	Date:	N/A

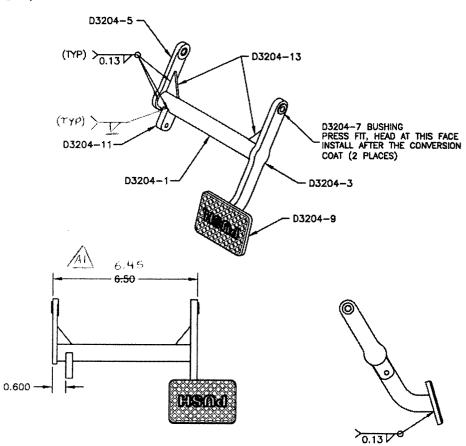
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	1
В	06.03.21	Dwg Rev update	KJ/JLM	101
		······································		





				* * * * * * * * * * * * * * * * * * * *
1	DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
7	CHECKED,	APPROVED	DRAWING NO.	REV. A
7	4	#	D3204	SHEET 1 OF 3
	DATE		TITLE	SCALE
	04.01.27		RELEASE PEDAL ASSEMBLY	NTS
	Α	04.01.27	NEW ISSUE	
	AI Off TO	05.07.15	6.45 WAS 6.50	





D3204-041 RELEASE PEDAL ASSEMBLY

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125) 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

TNCONTA LADER IN . N. . . .

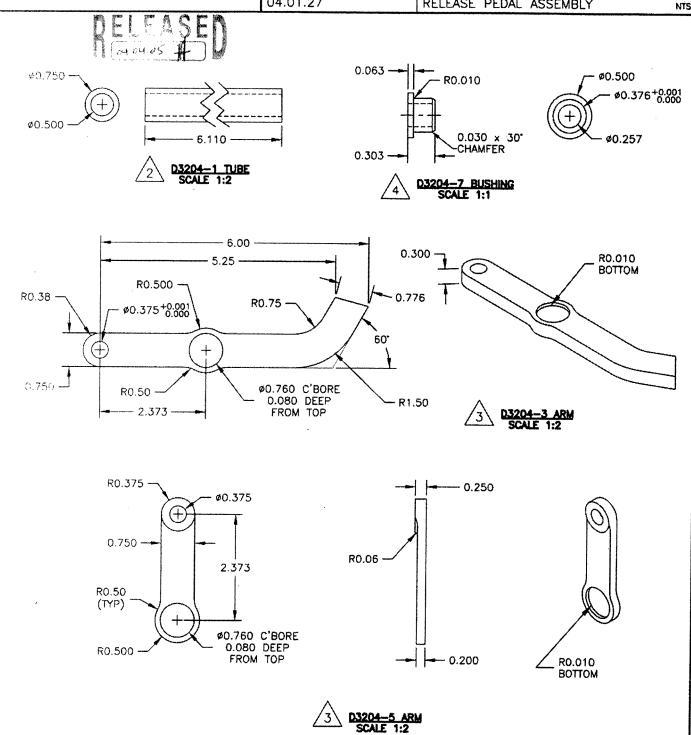
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





	And the state of t								
	DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA						
ſ	CHECKED ,	APPROVED	DRAWING NO.	- 7	REV.	Α			
۱	卌	1 #	D3204	SHEET	2 OF	3			
ſ	DATE		TITLE		SCA	LE			
ı	04.01.27		RELEASE PEDAL ASSEMBLY		N	πs			



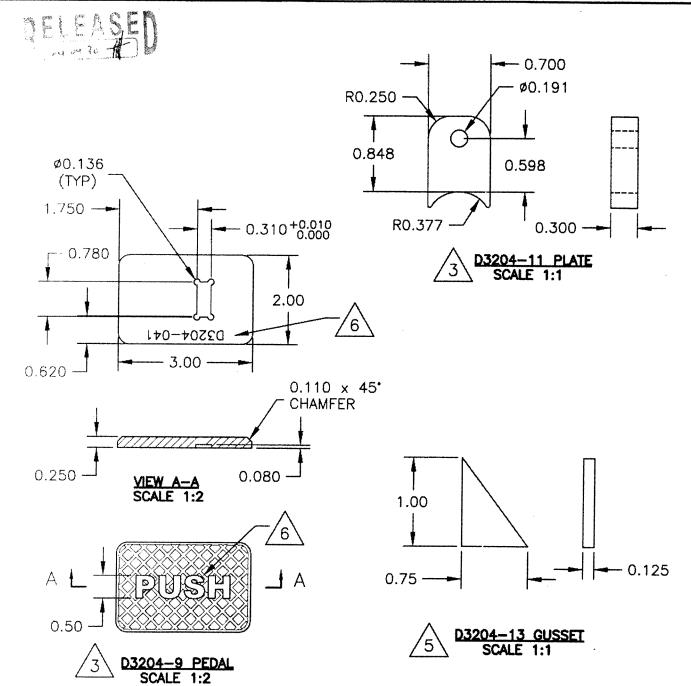
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DARY AEROSPACE LTD.





		The second secon	- Marindan Applementation	
DESIGN CAT	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA		
CHECKED	APPROVED	DRAWING NO. D3204	REV. A	
DATE	······································	TITLE	SCALE	
04.01.27		RELEASE PEDAL ASSEMBLY	NTS	,



Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.